

Work Order ID 68105

Page 1

Wednesday, April 06, 2011 2:27:19 PM

Item ID: D3490-1

Accept



Setup Start



Revision ID:

Item Name: Cross Bolt Spacer

Stop



Start Date: 4/6/2011 Start Qty: 60.00



Cust Item ID:

Required Date: 4/13/2011 Req'd Qty: 60.00



Customer:

Reference:

Approvals: Process Plan:



Date: 11-04-14

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3490	Rev A

100

0.00



Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

11-4-14

60

Hardinge CNC Lathe Small

1-TURN AS PER FOLIO FA628 & DWG D3490

FOLIO REV:

DWG REV:

2-DEBURR AS REQUIRED

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

11-4-14

60

Quality Control

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

SL 11/04/14

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Work Order ID 68105

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Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center ID

130



Packaging

Packaging

Operation
Description

Identify as per dwg & Stock Location

LG

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

60 0 86 u/04/15

11/4/18 JF

MF

11-04-15

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Picklist Print

Wednesday, April 06, 2011 2:27:25 PM

Page 1

Work Order ID: 68105



Parent Item: D3490-1



Parent Item Name: Cross Bolt Spacer

Start Date: 4/6/2011

Required Date: 4/13/2011

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP Rev:A New Issue 06-03-03 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.500W.049		Purchased	No			100	f	393.6670	0.266	16.8		Jul 11-4-14	

6061-T6 RD Tube .500 x.049W



Location	Loc Qty	Loc Code
MAT014	393.667	
117270	393.667	76

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	68105
Description: Crossbolt Spacer	Part Number:	D3490-1
Inspection Dwg: D3490	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>ml</u>	Audited by: <u>SL</u>	Prototype Approval: N/A
Date: <u>11-4-14</u>	Date: <u>11/04/14</u>	Date: N/A

Rev	Date	Change	Revised by	Approved
A	06.10.06	New Issue	KJ/JLM	
B	08.06.02	Dimensions and tolerances revised	KJ/DD	
C	08.10.07	0.050 x 45° dimension revised	KJ/DD	

W/O:		WORK ORDER CHANGES							
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NOTE: Date & initial all entries

DART

RETURN TO
ENGINEERING
UNCONTROLLED COPY

SUBJECT TO A WORK ORDER

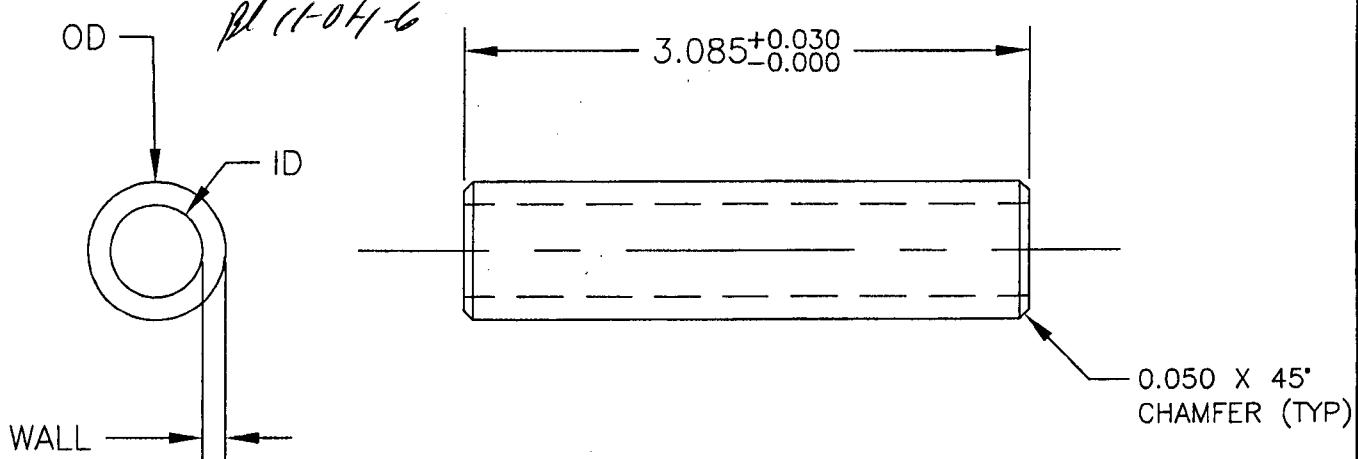
WITHOUT NOTICE

WORK ORDER

NO. 68104

DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>MM</i>	APPROVED <i>MM</i>	DRAWING NO. D3490	REV. A SHEET 1 OF 1
DATE 06.01.04		TITLE CROSS BOLT SPACER	SCALE NTS

A 06.01.04 NEW ISSUE

**D3490-1/-3/-5 CROSS BOLT SPACER PARTS LIST**

PART NUMBER	OD	WALL	ID (REF)	MATERIAL SPEC
D3490-1	0.500	0.049	0.402	M6061T6T0.500W.049
D3490-3	0.750	0.080	0.591	M6061T6R0.750
D3490-5	0.313	0.058	0.197	M6061T6T0.313W.058

D3490-1/-3/-5 CROSS BOLT SPACER

- 1) MATERIAL: ALUMINUM 6061-T6 (QQ-A-200/8 OR QQ-A-225/8)
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
06-02-07

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